

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003077**Date Inspected:** 18-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector observed ZPMC workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib press forming, drilling holes in connection areas, PJP bevel preparation, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding DP-602-001 and the PJP welding of closed ribs to deck plates. Deck Panels DP-541-001 and DP-611-001 were completely welded on gantry 1 and DP-304-001 was tack welded and in the ready position for welding on gantry 2.

This QA inspector received Notification of Witness Inspection number 550 from ZPMC for Final Ultrasonic Testing (UT) of internal diaphragm plates for U-rib DP602-001. Upon arrival to perform ultrasonic verification, Caltrans QA noted that ZPMC had accepted the CJP weldments and had fit the components to the flat plates. The Caltrans QA inspector was not able to perform the required UT verification as described in special provisions. ZPMC's Notification of Witness states that "When ZPMC QC is finished NDT inspections Caltrans QA can decide if they want to retest it. ZPMC QC will not inform Caltrans again. The waiting time is 24 hours ordinarily. "As stated. A incident report will be generated for this occurrence.

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Summary of Conversations:

As Noted Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
